

Date: Wednesday, 5/31/2006 7:33:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FOLDING STEP WELDMENT LH
Job Number : 27272	
Estimate Number : 10463	
P.O. Number : N/A	Part Number : D3388041
This Issue : 5/31/2006 S.O. No. : N/A	Drawing Number : D3388 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 27268	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 6/30/2006 Qty: 5 Um: Each
Checked & Approved By : <u>[Signature] 06.05.31</u>	
Comment : Est. B 05.06.10 Added Step 11 KJ/JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

D2622-120C extrusion 8

Batch: B 27077

FF 06-07-11 5

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion 85.15" long as per Dwg D3388

FF 06-07-11 5

2-Deburr and bevel ends for welding

FF 06-07-11 5

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

206 Step Endplate

Pick:

Qty

Part Number

Description

Batch

2

D2734

End Cap

327281=3
 324402=3

FF 06-07-11 5
 [Signature] 06-07-11 5

4.0

D33871

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty

Part Number

Description

Batch

2

D3387-1

Arm

327104

[Signature] 06-07-11 5

W/O: 1		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-26	6.1	QC 3 Inspect chemical conversion coat.	[Signature]	06-07-26	5	[Signature]	[Signature]	
	6.2	Inspect for Foreign objects, weld last end cap & grind flush. Al bond to ^{middle}	[Signature]	06-07-27	5	[Signature]	[Signature]	
	6.3	QC 5/9 inspect work to step: welds.	[Signature]	06-08-02		[Signature]	06-07-26	
06-07-26	4	Add these steps. Perim. Change [Signature]				[Signature]	[Signature]	
	6.4	Alodine end cap as per QS1005 4.1.		06-08-04		[Signature]	06-07-26	

NCR: <u>27272</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-01	5.0	2 steps have debris inside. Not big.	<i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i>	drill hole as necessary and remove all foreign objects. Fill hole with weld as per QS1005 and grind flush.	<i>[Signature]</i> 06-08-02	<i>[Signature]</i> 06-08-02	<i>[Signature]</i> 06-08-02	06-08-01

Part No: D3388-041 PAR #: N/A Fault Category: Peri - Lg. FIB NCR: Yes No DQA: Date: 06-08-24

NOTE: Date & initial all entries

QA: N/C Closed: Date: 06-08-24

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 27272

Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and end caps as per Dwg D3388.

Inspect for foreign objects as per QSI 024. Dwg Rev: A

Grind end cap welds flush

Handwritten: J.E. 06.07.20
C.E. 06.07.20
FF 06.07.20

Handwritten: PTO

Handwritten: 5
5
5

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: SAD 06.07.25

Handwritten: 5

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: a.m 06-08-08

Handwritten: PTO

Handwritten: on previous page

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

Handwritten: SC 06/08/08

Handwritten: 5

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect Powder Coat and Wing Walk

Handwritten: a.m 06-08-09

Handwritten: 5

10.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Pick:

Qty

Part Number

Description

Batch

1

D2808

Spacer

Handwritten: B27564

Handwritten: SAD 08.08.15

Handwritten: 5

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press spacer into D3387-1 arm as per Dwg D3387

Handwritten: SAD

Handwritten: 08.08.15

Handwritten: 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-20	S.1	Inspect Level 5/9 QC S/9 Done by: J. 06-07-21 / 06/07/21 (S)						
06-07-20	S.1	Add Previous step to estimate	E	06-07-20				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:33:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT LH

Job Number: 27272

Part Number: D3388041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP

06/08/15

5

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G.A.

N/A

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.24

Job Completion



u 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

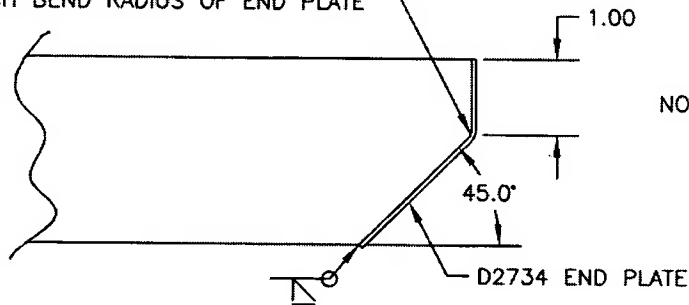
DART

RELEASED

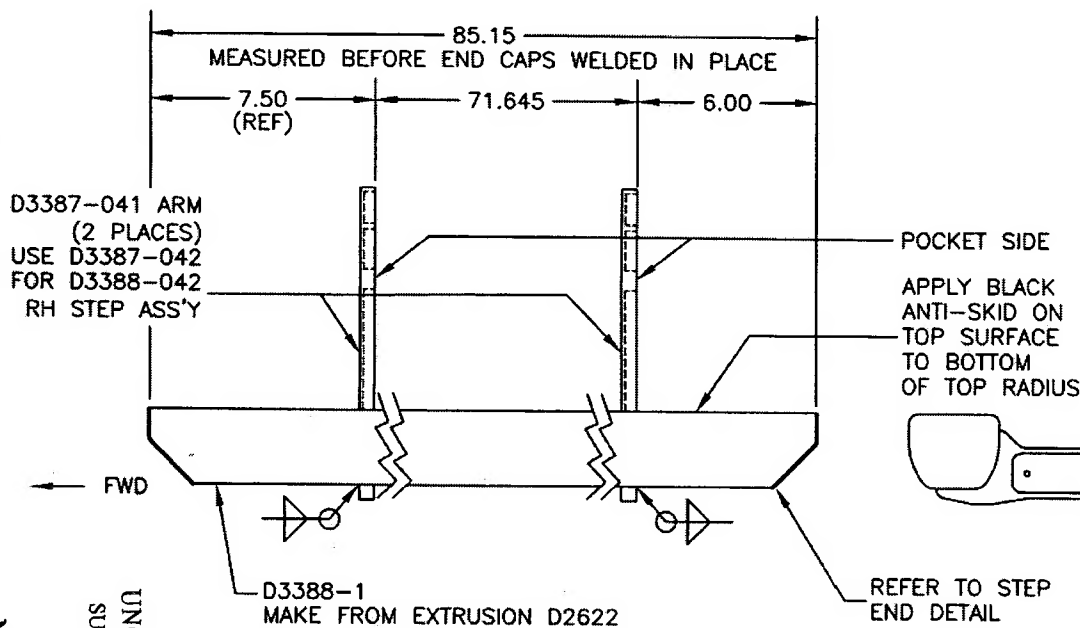
05-03-11

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE



D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WELD PER DART QSI 004 UNLESS OTHERWISE NOTED

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDEX (4.3.5.6)

OR BLACK SANDEX (4.3.5.7) OR GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DART AEROSPACE LTD
HAMKESBURY, ONTARIO, CANADA

REV. A

SHEET 1 OF 1

SCALE

NTS

DATE
05.01.20
TITLE
STEP WELDMENT

A

05.01.20

NEW ISSUE